

Work Order ID 67081

Monday, March 07, 2011 2:59:14 PM

Page 1

Item ID: D412-711-101

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Bubble Window

Start Date: 3/7/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D412-711-101

A

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefiles and create labels
for PPP D412-711-101 Change 002

JG for BG 11-3-15

110

0.00



HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

0.00

Set up Machine as per folio FTA 077 and D711W program using mould DT9640

JH
11/03/09

120

0.00



HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

0.00

Cut Blanks to 36" by 39"

x2 JH
11/03/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Replacement Bubble Window

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Start Date: 3/7/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA 077 <u>A</u> Dwg. Rev. <u>A</u> Folio Rev.	0.00 0.00				<u>x2</u>			<u>Wh</u> <u>11/03/09</u>
140 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo 1) Check Surface finish for undesired marks, voids, dimples etc. 2) Check depth of bubble to ensure conformity to drawing tolerances.	0.00 0.00				<u>x2</u>			<u>Wh</u> <u>11/03/09</u>
150 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<u>S u103/14</u>		<u>(x2)</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 2.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  HandThermo	HAND FINISHING THERMOFORMING	0.00				x2			DL 11/03/14
Hand Finishing Thermoforming	Memo 1) Trim off excess flange material 2) Buff out any light scratches or 3) Etch part number and batch number	0.00							
170  QC	QC2- Inspect parts off machine FAI/FAIB	0.00				x2			DL 11/03/14
Quality Control	Memo 1) Visually inspect for clarity, and proper formation.	0.00							
180  QC	QC5- Inspect part completeness to step on W/O	0.00				(x2)			DL 11/03/14
Quality Control	Memo 1) Visually inspect for clarity, and proper formation.	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start

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Item Name: Replacement Bubble Window

Start Date: 3/7/2011 Start Qty: 2.00

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Required Date: 3/11/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

185

QC4- 100% Inspect kits for completeness

0.00

8/03/15



QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location: 9.1

0.00

REOC



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/15 JF

MF
11-03-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 67081



Parent Item: D412-711-101



Parent Item Name: Replacement Bubble Window

Start Date: 3/7/2011

Required Date: 3/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
Manufacture in-house 10/06/28 DL

IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MACRLICS.236

Purchased

No

sf

168.0000

32



Plexiglass G .236"

Location

Loc Qty

Loc Code

therm

168

115590

8

116030

160

32

Wh
11/03/14

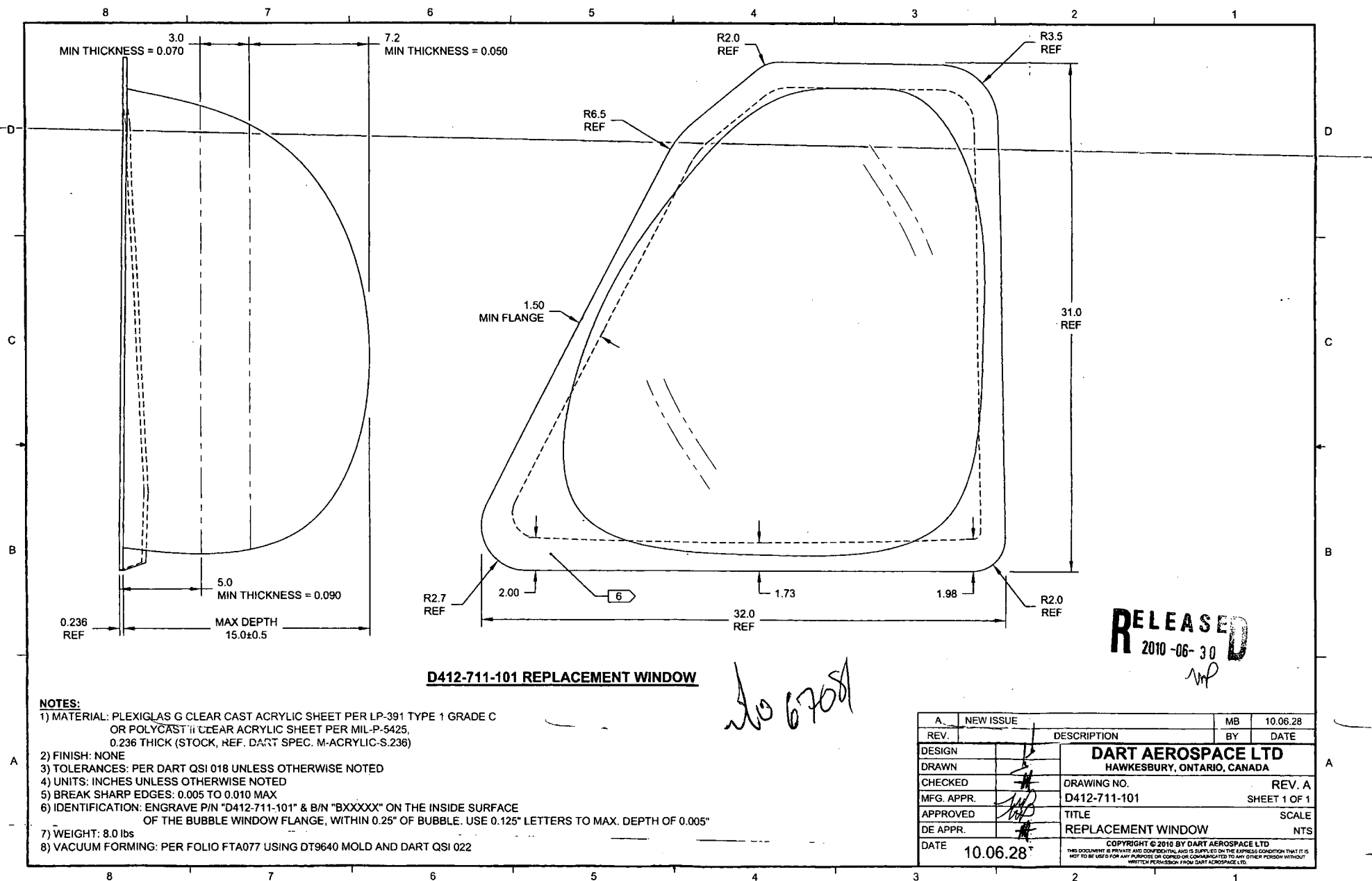
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 67081
Description:	Part Number: D412-711-101
Inspection Dwg: D412-711-101 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>W.L.</u>	Date: <u>11/03/09</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.0"	R _{0.5} F	32.25"	✓		TAPE DL-01	
31.0"	R _{0.5} F	30.875"	✓		TAPE DL-01	
1.5"	MIN.	1.62"	✓		Vern DL-02	
1.73"	± 0.030"	1.75"	✓		Vern DL-02	
2.00"	± 0.030"	2.01"	✓		Vern DL-02	
0.090"	MIN	0.093"	✓		ULTRA	
0.070"	MIN	0.089"	✓		ULTRA	
0.050"	MIN	0.080"	✓		ULTRA	
15.0"	± 0.5"	15.375"	✓		TAPE DL-01	

Measured by: <u>W.L.</u>	Date: <u>11/03/10</u>
Audited by: <u>JPB</u>	Date: <u>11/03/10</u>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14

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DART AEROSPACE LTD	Work Order: 67081
Description:	Part Number: 0412-711-101
Inspection Dwg: 0412-711-101 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "	<input checked="" type="checkbox"/>	<input type="checkbox"/>		
Shape Definition	<input checked="" type="checkbox"/>	<input type="checkbox"/>		
Texture Retention	<input checked="" type="checkbox"/>	<input type="checkbox"/>		
Material imperfections such as bumps, cracks, voids, scratching	<input checked="" type="checkbox"/>	<input type="checkbox"/>		
	<input type="checkbox"/>	<input type="checkbox"/>		
	<input type="checkbox"/>	<input type="checkbox"/>		
	<input type="checkbox"/>	<input type="checkbox"/>		
	<input type="checkbox"/>	<input type="checkbox"/>		

Measured by: <u>DL</u>	Date: <u>11/03/09</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.0"	Ref	32.25"	<input checked="" type="checkbox"/>	<input type="checkbox"/>		
31.0"	Ref	31.0"	<input checked="" type="checkbox"/>	<input type="checkbox"/>		
1.5"	MIN	1.68	<input checked="" type="checkbox"/>	<input type="checkbox"/>		
1.73"	+/- 0.030"	1.71"	<input checked="" type="checkbox"/>	<input type="checkbox"/>		
2.00"	+/- 0.030"	2.01"	<input checked="" type="checkbox"/>	<input type="checkbox"/>		
0.090"	MIN	0.097"	<input checked="" type="checkbox"/>	<input type="checkbox"/>		
0.070"	MIN	0.093"	<input checked="" type="checkbox"/>	<input type="checkbox"/>		
0.050"	MIN	0.080"	<input checked="" type="checkbox"/>	<input type="checkbox"/>		
15.0"	+/- 0.50"	15.5"	<input checked="" type="checkbox"/>	<input type="checkbox"/>		
			<input type="checkbox"/>	<input type="checkbox"/>		
			<input type="checkbox"/>	<input type="checkbox"/>		
			<input type="checkbox"/>	<input type="checkbox"/>		

Measured by: <u>DL</u>	Date: <u>11/03/10</u>
Audited by: <u>JB</u>	Date: <u>11/03/10</u>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14